



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-84A

Job Sheet R194439



5029116
P.

Part No: 20NR-84A

Job Qty: 2 pcs

Part Name: Spacer for Dual Cage 4



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 5/30/19

Created By: Jennifer Renwick

Type: Rework

Description:

Note:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
300	Rework Startup	2 pcs	5/30/19	5/30/19	0.00	0.33	Handfinish - 7 - 1 Handfinish - 7 - 2			B.A 19-05-02
310	Mill Conv	2 pcs	5/30/19	5/30/19	0.00	0.33	Conventional Mill - 1 - B4B			B.A 19-05-02
320	QC 2	2 pcs	5/30/19	5/30/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			
							QC 2 - 65			
							QC 2 - 5			
							QC 2 - 71			
330	QC 8	2 pcs	5/30/19	5/30/19	0.00	0.00	QC 8 - 12			B.A 19-05-02
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			



Container No: S177607



Part: 20NR-84A

Job No: R194439

Serial No/ Batch: S177607

Revision: 2

Inspector:

Exp. Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/02/19

SCRAP

Plex 5/2/19 11:57 AM Dart.Renwick.Jennife

				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
340	Outsource - 1 - Heat Treat	2 pcs	5/30/19	0.00 0.00	ATL 002-VC 2019-05-03 KA
350	Packaging 2-1 - Receive - B4B	2 pcs	5/30/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
360	QC 6	2 pcs	5/30/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
370	Outsource - 15 - Nickel Plate	2 pcs	5/30/19	0.00 0.00	GRO002 KA 2019-05-31
380	Packaging 2-2 - Receive - B4B	2 pcs	5/30/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B

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				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
390	QC 6	2	5/30/19	0.00 0.00	QC 6 - 9
		pcs			QC 6 - 68
					QC 6 - 61
					QC 6 - 40
400	Packaging 3-1 - Stock - B4B	2	5/30/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
410	QC 21 - SA	2	5/30/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70

Plex 5/2/19 11:57 AM Dart.Renwick.Jennifer

QC 21 - SA - 53

Part Op **300** - BEAD BLAST
Descriptions: **310** - USE OVER SIZED TAP TO OVERSIZE THREAD
340 - 1- Issue P/O _____ RC 33-37 2-Bead blast 3- Certificate of Conformity is required
370 - -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required
400 - ID AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-84AP	Spacer Dual Cage 4, 1/2" Hole	2 pcs (1 ea)	300-Rework Startup	<u>5029116</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
300-Rework Startup	20NR-84AP	2	2	0

Part Specifications

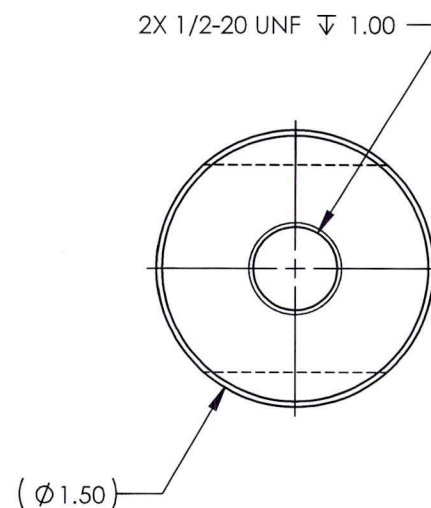
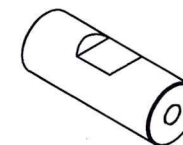
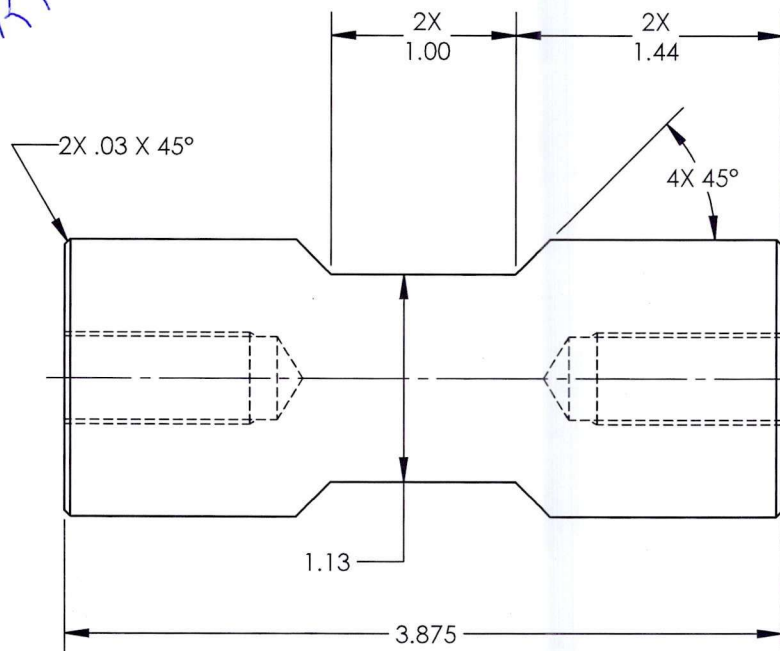
Specifications could not be found.

Plex 5/2/19 11:57 AM Dart.Renwick.Jennifer

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	AS DRAWN BY CANAM	7/19/2013	CFS
2	CH'D FINISH TO NICKEL PLATE	10/8/2013	JAG

Job
R194439



1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

USED ON
20NR-DHC
20NR-DHRC
20NR-DHCA

RED BARN MACHINE	
TITLE SPACER DUAL CAGE 4, 1/2" HOLE	
DWG NO. 20NR-84A	REV 2
MAT'L 1045	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT RC 33-37
.XX ± .01 ANGLES ± 5°	FINISH NICKEL PLATE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 11/6/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-84A	1	SPACER DUAL CAGE 4, 1/2" HOLE	1045	Ø1-1/2 X 4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043375



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043375

PO Date: 5/3/19

Due Date: 5/9/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192149	C45-15	Keeperless Adapter 1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC 44- 46 _____ 2-Bead blast 3-Material type; 4140 4- Certificate of Conformity is required	Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$28.3333/pcs	\$170.00
2	192392	RB877212-08-7	Cutter, Ø1-1/2 x 5/8 Outsource process - Heat Treat 1-Issue P/O; _____ RC 50-60 2-Bead blast 3- Certificate of Conformity is required MT-O1-R1.500 Tool Steel Round Bar 1.5 dia	Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00
3	190623	20NR-84	Spacer for Dual Cage 6 1-Issue P/O; _____ RC 33-37 2-Bead blast 3-Material type; 1045 4- Certificate of Conformity is required	Firmed	-	5/9/19	4 pcs	0 pcs	4 pcs	\$26.90/pcs	\$107.60
	191157			Firmed	-	5/9/19	6 pcs	0 pcs	6 pcs	\$26.90/pcs	\$161.40
Sub Total:							10	0	10		\$269.00

Plex 5/14/19 1:01 PM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043375



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	R194439	20NR-84A	Spacer for Dual Cage 4 1- Issue P/O _____ RC 33-37 2-Bead blast 3- Certificate of Conformity is required MAT'L 1045	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$67.25/pcs	\$134.50
6	R194446	20NR-84B	Spacer Dual Cage 4, 5/8" hole 1- Issue P/O _____ RC 33-37 2-Bead blast 3- Certificate of Conformity is required MAT'L 1045	Firmed	-	5/9/19	3 pcs	0 pcs	3 pcs	\$44.8333/pcs	\$134.50
Grand Total:											\$783.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/14/19 1:01 PM Dart.Guerin.Kimberley

Atlantic Heat Treating (2001) Ltd

Order No.: 165984

Ship Date: 5/7/2019

Shipping Ticket

Sold To:

1448

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To:

162926

DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB043375 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
----------	---	--------

2 PCS MATERIAL 1045
CASE TO 0.030" HEAT TREAT TO 33-37RC
SANDBLAST, C OF C, PRT# 20NR-84A, JOB# R194439 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

2

Pounds Shipped:

4.00

RECEIVED

MAY 27 2019

DART AEROSPACE LTD.

35 RC ¹⁰²

5-24-19

Order No.: 165984

Shipped Complete

Quantity Shipped:

2.00

Received By:

Date:

Pounds Shipped:

4.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 05/07/2019

Certification

Date: 05/24/2019

Entry Date: 05/07/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB043375 ✓

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 1045

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
2	2 PCS MATERIAL 1045 CASE TO 0.030" HEAT TREAT TO 33-37RC SANDBLAST, C OF C, PRT# 20NR-84A, JOB# R194439	4

DAS
68
9-89

Insp. Type	Scale	Minimum	Maximum	Number	Other
------------	-------	---------	---------	--------	-------

Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 33. 37. 35. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 35 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

KEAN SHEPHERD
QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043596



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043596

PO Date: 5/31/19

Due Date: 6/7/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-03

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195179	20NR-84B	Spacer Dual Cage 4, 5/8" hole -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Material type; 1045 -Certificate of Conformity is required	Firmed	-	6/4/19	4 pcs	0 pcs	4 pcs	\$9.2307/pcs	\$36.92
Line Item Note *****REQUIRED A.S.A.P*****											
2	R194439	20NR-84A	Spacer for Dual Cage 4 -Issue P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 - Bake After Plating - Certificate of Conformity is required	Firmed	-	6/7/19	2 pcs	0 pcs	2 pcs	\$9.2307/pcs	\$18.46
3	193465	C45-15-6	Bushing, Lifting Outside Processing - Nickel Plate)ISSUE P/O TO GROUPE ALTECH: QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE TO .0004-.0006 BAKE AFTER PLATING C OF C IS REQUIRED	Firmed	-	6/7/19	20 pcs	0 pcs	20 pcs	\$9.2307/pcs	\$184.61
Grand Total:											\$240.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043596



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in dark ink, appearing to be "JL" or similar, located to the right of the Order Notes section.

Plex 6/3/19 8:46 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(019659-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**019659 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
05-Jun-2019		SPARTAKOS BOUNTOURIS		POHB043596 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	20NR-84B ✓ Rev.	20NR-84B 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	4	4	0	0	0
2	20NR-84A ✓ Rev.	20NR-84A 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290, CLASS 2, GRADE E OR F THICKNESS 0.0004-0.0006 BAKE AFTER PLATING	E-NICKEL STEEL CH	2	2	0	0	0
3	C45-15-6 ✓ Rev.	C45-15-6 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE TO 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	20	20	0	0	0

RECEIVED
JUN 05 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

3 small boxes

Épaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043596



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043596
PO Date: 5/31/19
Due Date: 6/7/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-06-03

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195179	20NR-84B	Spacer Dual Cage 4, 5/8" hole -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Material type; 1045 -Certificate of Conformity is required	Firmed	-	6/4/19	4 pcs	0 pcs	4 pcs	\$9.2307/pcs	\$36.92
Line Item Note ****REQUIRED A.S.A.P****											
2	R194439	20NR-84A	Spacer for Dual Cage 4 -Issue P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Bake After Plating - Certificate of Conformity is required	Firmed	-	6/7/19	2 pcs	0 pcs	2 pcs	\$9.2307/pcs	\$18.46
3	193465	C45-15-6	Bushing, Lifting Outside Processing - Nickel Plate)ISSUE P/O TO GROUPE ALTECH: QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE TO .0004-.0006 BAKE AFTER PLATING C OF C IS REQUIRED	Firmed	-	6/7/19	20 pcs	0 pcs	20 pcs	\$9.2307/pcs	\$184.61
Grand Total:											\$240.00



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Canada

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PURCHASE ORDER
POHB043596



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in blue ink, likely belonging to a representative of Dart Aerospace.

Plex 6/3/19 8:46 AM Dart.Guerin.Kimberley



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SUBCONTRACT SHIPPER

SUBCONTRACT SHIP TO

Ship To: Group Altech
2455 Halpern
St Laurent, QC H4S 1N9 Canada
Phone: 514-335-3666 **Fax:** 514-335-3868

SHIPPER

Shipper No: 1384
Shipper Date: 5/31/19
Carrier: *
Ship Via:
Vehicle Reg:
Note:
Freight Terms:

Part Information

Part No: 20NR-84A	Name: Spacer for Dual Cage 4
Cust Part No:	Product Family: External Load
Reference No:	Piece Weight: 0 lbs
Part Information Note: DWG 20NR-84A Rev 2 IPP Rev. A 19.05.15 New issue DP Verify DD	Alloy Type:
Drawing No:	Alloy - Temper: -
Program:	Description:
Program Customer:	Quantity:
Addl Docs:	
Commercial: Product Line: External Load - Spare Primary OEM Application: Generic Manufacturer: DART Sales Lead Time: 8 weeks Business Segment: Tools & GSE Advertised on web?: Yes	

OPERATION

Operation: Outsource - 15 - Nickel Plate - 370
Description: -Issue P/O _____ -Nickel plate, QQ-N-290,
Class 2, Grade E or F -Nickel Plate .0004- .0006 -
Certificate of Conformity is required
Note:

DETAIL

Part	Operation	PO	Job	Container	Heat Code	Net Weight (lbs)	Gross Weight (lbs)	Quantity
20NR-84A	Outsource - 15 - Nickel Plate -Issue P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	POHB043596	R194439	S177607		0	0	2
20NR-84B	Outsource - 15 - Nickel Plate -Issue P/O; _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating - Material type; 1045 -Certificate of Conformity is required	POHB043596	195179	S182301		0	0	4
C45-15-6	Outsource - 15 - Nickel Plate Outside Processing - Nickel Plate)ISSUE P/O TO GROUPE ALTECH; _____ QQ-N-290, CLASS 2 GRADE E OR F. NICKEL PLATE TO .0004-.0006 C OF C IS REQUIRED	POHB043596	193465	S180462		0	0	20
Total				3		0	0	26

Driver Signature _____



Certificat de Conformité / Certificate of Compliance

(019659-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

019659 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
05-Jun-2019		SPARTAKOS BOUNTOURIS		POHB043596 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	20NR-84B ✓ Rev.	20NR-84B 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	4	4	0	0	0
2	20NR-84A ✓ Rev.	20NR-84A 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290, CLASS 2, GRADE E OR F THICKNESS 0.0004-0.0006 BAKE AFTER PLATING	E-NICKEL STEEL CH	2	2	0	0	0
3	C45-15-6 ✓ Rev.	C45-15-6 01-E-NIC STEEL 500 [E-NICKEL STEEL 500] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE TO 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL STEEL CH	20	20	0	0	0

RECEIVED

JUN 05 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

3 small boxes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

ewal

⏮ Reply all ▾ 🗑 Delete ⓧ Junk Block ...

POHB043596 Group Altech

NE

Natasha Belanger

Wed 6/5/2019 2:08 PM

Natasha Belanger ▾

Good afternoon,

Upon receiving above PO, job# R194439 Qty.2, will not allow me to receive, I am getting the following message:



Container(s) no longer eligible for receipt.

⬅ Back

Thank you,
Natasha

Warehouse Receiver

DART AEROSPACE

T 1 613 632-5200 > 248

F 1 613 632-5246

1 800 556- 4166

www.dartaerospace.com

SCRAP

Manual Receipt in voice
- Note in container.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

Container History for S177607

Change Date	By	Job	Part	Rev	Operation	Material	Chg	Serial No/Batch	Gross	Tare	Net	Len	Qty	Location	Status	Accounting Job	Defect	Type	Last Action	From	Shelf Date	Loade
5/2/19 5:58 PM	Audclair, Guillaume	R194439	20NR-84A		Rework Startup			S177607	0	0	0	0	0	Handfinish - 7 - 1	WIP				Created at Control Panel			No
5/2/19 5:58 PM	Audclair, Guillaume	R194439	20NR-84A		Rework Startup			S177607	0	0	0	0	2	Handfinish - 7 - 1	WIP				Production Recorded at Control Panel			No
5/2/19 5:58 PM	Audclair, Guillaume	R194439	20NR-84A		Rework Startup			S177607	0	0	0	0	2	Handfinish - 7 - 1	Allocated				Production Update	S029116	5/2/19	No
5/2/19 6:21 PM	Audclair, Guillaume	R194439	20NR-84A		Rework Startup			S177607	0	0	0	0	2	Conventional Mill - 1 - B4B	Allocated				Loaded to Workcenter	S029116	5/2/19	Yes
5/2/19 6:21 PM	Audclair, Guillaume	R194439	20NR-84A		Conventional Mill - 1 - B4B			S177607	0	0	0	0	2	Conventional Mill - 1 - B4B	Allocated				Record Operation	S029116	5/2/19	No
5/2/19 6:21 PM	Audclair, Guillaume	R194439	20NR-84A		Conventional Mill - 1 - B4B			S177607	0	0	0	0	2	Conventional Mill - 1 - B4B	Allocated				Production Recorded at Control Panel	S029116	5/2/19	No
5/2/19 6:21 PM	Audclair, Guillaume	R194439	20NR-84A		Conventional Mill - 1 - B4B			S177607	0	0	0	0	2	Conventional Mill - 1 - B4B	WIP				Container Full	S029116	5/2/19	No
5/2/19 6:26 PM	Audclair, Guillaume	R194439	20NR-84A		Conventional Mill - 1 - B4B			S177607	0	0	0	0	2	QC 2 - 8	WIP				Loaded to Workcenter	S029116	5/2/19	Yes
5/2/19 6:26 PM	Audclair, Guillaume	R194439	20NR-84A		QC 2			S177607	0	0	0	0	2	QC 2 - 8	WIP				Record Operation	S029116	5/2/19	No
5/2/19 6:26 PM	Audclair, Guillaume	R194439	20NR-84A		QC 2			S177607	0	0	0	0	2	QC 2 - 8	WIP				Production Recorded at Control Panel	S029116	5/2/19	No
5/2/19 6:26 PM	Audclair, Guillaume	R194439	20NR-84A		QC 2			S177607	0	0	0	0	2	QC 2 - 8	WIP				Container Full	S029116	5/2/19	No
5/3/19 11:22 AM	Lamarche, Mathieu	R194439	20NR-84A		QC 2			S177607	0	0	0	0	2	QC 8 - 14	WIP				Loaded to Workcenter	S029116	5/2/19	Yes
5/3/19 11:23 AM	Lamarche, Mathieu	R194439	20NR-84A		QC 8			S177607	0	0	0	0	2	QC 8 - 14	WIP				Record Operation	S029116	5/2/19	No
5/3/19 11:23 AM	Lamarche, Mathieu	R194439	20NR-84A		QC 8			S177607	0	0	0	0	2	QC 8 - 14	WIP				Production Recorded at Control Panel	S029116	5/2/19	No
5/3/19 11:23 AM	Lamarche, Mathieu	R194439	20NR-84A		QC 8			S177607	0	0	0	0	2	QC 8 - 14	WIP				Container Full	S029116	5/2/19	No
5/3/19 2:29 PM	Guerin, Kimberley	R194439	20NR-84A		QC 8			S177607	0	0	0	0	2	ATL002-VC	WIP				Sent to Subcontract - 1330	S029116	5/2/19	No
5/28/19 6:45 AM	Belanger, Natasha	R194439	20NR-84A		Outsource - 1 - Heat Treat			S177607	0	0	0	0	2	Packaging 2 - 5 - B4B	WIP				Received from Subcontract - bin-for-bin	S029116	5/2/19	No
5/28/19 6:45 AM	Belanger, Natasha	R194439	20NR-84A		Outsource - 1 - Heat Treat			S177607	0	0	0	0	2	Packaging 2 - 5 - B4B	WIP				Loaded to Workcenter	S029116	5/2/19	Yes
5/28/19 6:45 AM	Belanger, Natasha	R194439	20NR-84A		Packaging 2-1 - Receive - B4B			S177607	0	0	0	0	2	Packaging 2 - 5 - B4B	WIP				Record Operation	S029116	5/2/19	No
5/28/19 6:45 AM	Belanger, Natasha	R194439	20NR-84A		Packaging 2-1 - Receive - B4B			S177607	0	0	0	0	2	Packaging 2 - 5 - B4B	WIP				Production Recorded at Control Panel	S029116	5/2/19	No
5/28/19 6:45 AM	Belanger, Natasha	R194439	20NR-84A		Packaging 2-1 - Receive - B4B			S177607	0	0	0	0	2	Packaging 2 - 5 - B4B	WIP				Container Full	S029116	5/2/19	No
5/30/19 2:21 PM	Chuprun, John	R194439	20NR-84A		Packaging 2-1 - Receive - B4B			S177607	0	0	0	0	2	QC 6 - 68	WIP				Loaded to Workcenter	S029116	5/2/19	Yes
5/30/19 2:21 PM	Chuprun, John	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	QC 6 - 68	WIP				Record Operation	S029116	5/2/19	No
5/30/19 2:21 PM	Chuprun, John	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	QC 6 - 68	WIP				Production Recorded at Control Panel	S029116	5/2/19	No
5/30/19 2:22 PM	Chuprun, John	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	QC 6 - 68	WIP				Container Full	S029116	5/2/19	No
5/31/19 8:23 AM	Macdonald, Dara	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	GA210E	WIP				Container Move	S029116	5/2/19	No
5/31/19 8:24 AM	Macdonald, Dara	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	GA210E	Stock				Updated at Container Form	S029116	5/2/19	No
5/31/19 8:44 AM	Guerin, Kimberley	R194439	20NR-84A		QC 6			S177607	0	0	0	0	2	GRO002-VC	Stock				Sent to Subcontract - 1384	S029116	5/2/19	No
5/31/19 12:30 PM	Boucher, Sylvie	190597	20NR-84A		QC 6			S177607	0	0	0	0	2	GRO002-VC	Allocated				Added new job allocation, Job No: 190597	S029116	5/2/19	No
5/31/19 1:47 PM	Lacelle, Linda	190597	20NR-84A		QC 6			S177607	0	0	0	0	2	Small Fab - 3	Allocated				Updated at Job Allocation	S029116	5/2/19	No
5/31/19 1:47 PM	Lacelle, Linda	190597	20NR-84A		QC 6			S177607	0	0	0	0	2	Small Fab - 3	Allocated				Updated job allocation, Job No: 190597	S029116	5/2/19	No
5/31/19 2:42 PM	Lacelle, Linda	190597	20NR-84A		QC 6			S177607	0	0	0	0	2	Small Fab - 3	Stock				Deleted job allocation, Job No: 190597	S029116	5/2/19	No

- Close JOB ops to what it should be after Realsource
- update container
-